

Work Order ID 62020

Wednesday, September 15, 2010 10:01:38 A

Page 1

Item ID: D2858-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Hinge Bracket

Start Date: 9/14/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 9/21/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2858

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 5.850
" Note: 1 Blank Makes 3 Parts

SL 10/11/10

(7)

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA941
FOLIO REV: 8
DWG REV: 8
2-Deburr any rough edges

SL 10/12/08

(21)

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 10/12/08

(21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Page 2

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Required Date:	9/21/2010	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8 - Inspect parts - second check Memo	0.00 0.00		B.A 10/12/08		21	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		M 10/12/09		21	0		
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M115951. Memo START TIME: 10:55 300° FINISH TIME: 11:25	0.00 0.00				21.		10-12-13.	

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 3

Item ID: D2858-2

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Setup Start

Revision ID:

Stop

Item Name: Hinge Bracket

Start Date: 9/14/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 9/21/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

= 2.00

10/12/17

21

0



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

020

0.00



Packaging

Memo

0.00

Packaging

10/12/13 21

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/12/03
MF
10-12-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 15, 2010 10:01:42 AM

Page 1

Work Order ID: 62020



Parent Item: D2858-2



Parent Item Name: Hinge Bracket

Start Date: 9/14/2010

Required Date: 9/21/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP ☐ C00.06.22 ☐ Removed P/O for powder coat ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.25 0		Purchased	No			110	f	39.0492	0.163	3.431579			



6061-T6 Bar 1.50 x 1.25



22 10/11/10

Location

MAT10

107461

110936

Loc Qty

39.04915

11.26315

27.786

Loc Code

- 3.5

W/O:		WORK ORDER CHANGES					
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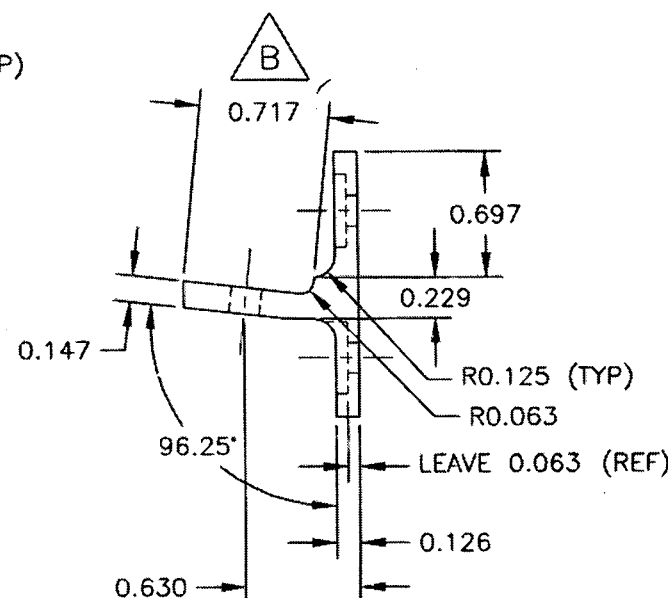
NOTE: Date & initial all entries

DART

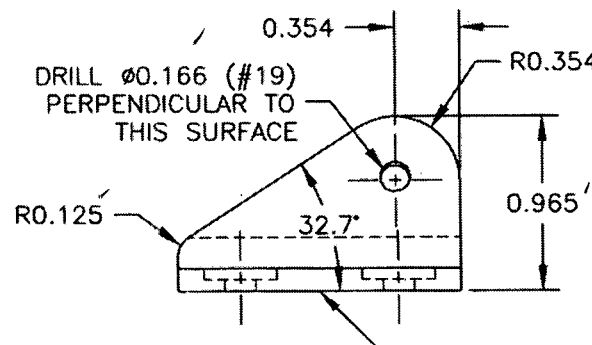
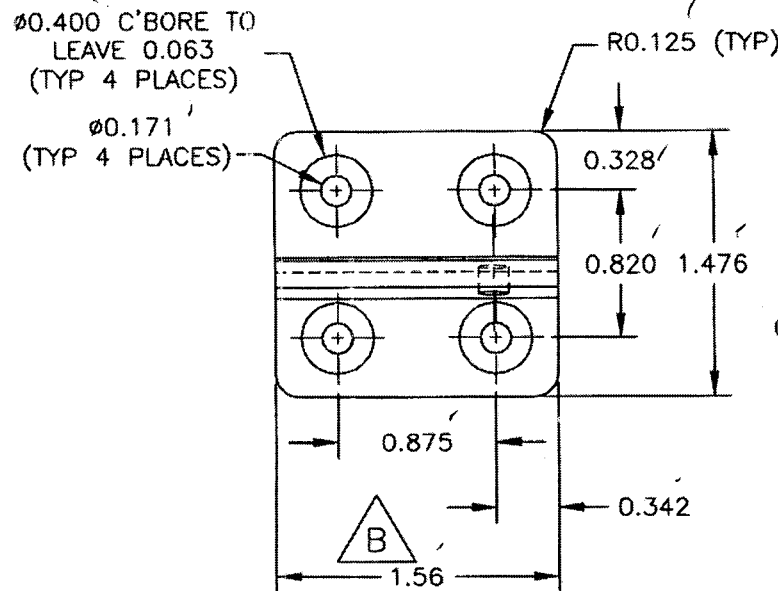


RELEASED
99.02.09 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>VE</i>	APPROVED <i>VE</i>	HAMKESBURY, ONTARIO, CANADA
DATE 99.02.28	DRAWING NO. D2858	REV. B
	TITLE HINGE BRACKET	SHEET 1 OF 1
		SCALE 1:1
A	98.12.14	NEW ISSUE
B	99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559



SHOP
RETURN
ENGINEER
UNCONTROLLED
SUBJECT TO
VTTCH
WORK
NO. *62020*
8/10-9-13



ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 62020
Description: hinge bracket		Part Number: A2858-2
Inspection Dwg: A2858 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of inspection	Comments
400	$\pm .010$	401	✓		vern JL-3	
6.171	$\pm .005$	173	✓		"	
875	$\pm .010$	875	✓		"	
1.56	$\pm .030$	1.563	✓		"	
342	$\pm .010$	345	✓		"	
1.476	$\pm .010$	1.479	✓		"	
820	$\pm .010$	820	✓		"	
328	$\pm .010$	330	✓		"	
1.125	$\pm .010$	125	✓		R-G	
354	$\pm .010$	354	✓		vern JL-3	
8.166	$\pm .005$	166	✓		"	
1.125	$\pm .010$	125	✓		R-G	
965	$\pm .010$	965	✓		vern JL-3	
717	$\pm .010$	722	✓		H-G	
147	$\pm .010$	149	✓		vern JL-3	
630	$\pm .010$	628	✓		"	
126	$\pm .010$	126	✓		"	
063	$\pm .010$	063	✓		"	
1.063	$\pm .010$	063	✓		R-G	
1.125	$\pm .010$	125	✓		"	
229	$\pm .010$	231	✓		"	
697	$\pm .010$	697	✓		"	

Measured by: SL	Audited by: B.A	Preliminary Approval:
Date: 10/12/08	Date: 10/12/08	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

OK

10.04.15